

Date: Wednesday, 4/5/2006 3:29:59 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---|------------------|--------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : BRACKET ASSEMBLY |
| Job Number | : 26564 | | |
| Estimate Number | : 11030 | | |
| P.O. Number | : N/A | Part Number | : D2803042 |
| This Issue | : 4/5/2006 | S.O. No. | : N/A |
| Prsht Rev. | : NC | Drawing Number | : D2803 REV B |
| First Issue | : N/A | Project Number | : N/A |
| Previous Run | : 25918 | Drawing Revision | : B |
| | | Material | : N/A |
| | | Due Date | : 4/27/2006 |
| Written By | : <u>See comment below</u> | Qty: | 10 Um: Each |
| Checked & Approved By | : <u>06.04.06</u> | | |
| Comment | : Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------|----------------|
| 1.0 | D28032 | STA 84 Bracket |
|-----|--------|----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 STA 84 BRACKET

Pick:

| | | | |
|-----|-------------|-------------|-----------------|
| Qty | Part Number | Description | Batch |
| 1 | D2803-2 | Bracket | <u>B26588</u> ✓ |

| | | |
|-----|--------|------|
| 2.0 | D28052 | Stop |
|-----|--------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 STOP

Pick:

| | | | |
|-----|-------------|-------------|-----------------|
| Qty | Part Number | Description | Batch |
| 1 | D2805-2 | Stop | <u>B25932</u> ✓ |

| | | |
|-----|-------|---------|
| 3.0 | D2809 | Bushing |
|-----|-------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Bushing

Pick:

| | | | |
|-----|-------------|-------------|---------------|
| Qty | Part Number | Description | Batch |
| 1 | D2809 | Bushing | <u>B25959</u> |

Press D2805-2 into arm as per Dwg D2803

JAD 06:05:02 (10)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 4/5/2006 3:29:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 26564

Part Number: D2803042

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

Q02
Q05
A

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Inspect work

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/05/04

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803

SAD 06:05:06

8.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3C16A Bolt

M17944

9.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch

2 MS21043-3 Nut

M100218

10.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

4 NAS1515H3 Washer

M19633


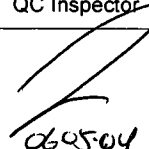
A/R LPS-3 Corrosion Spray

M17045

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

SAD 06:05:06

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | |
|--------|------|---|----|------|-----|---|---|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| 060504 | 4 | QCS req'd for inspection of press fit. permanent change. | | | |  |  060504 | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LD Date: 06/05/12
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 4/5/2006 3:30:00 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 26564

Part Number: D2803042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D2803.

SAP 06/05/06 (12)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/05/06 10

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: S7158

6/5/11

10

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

DP 06/05/12 (10)

Job Completion



U 06-05-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

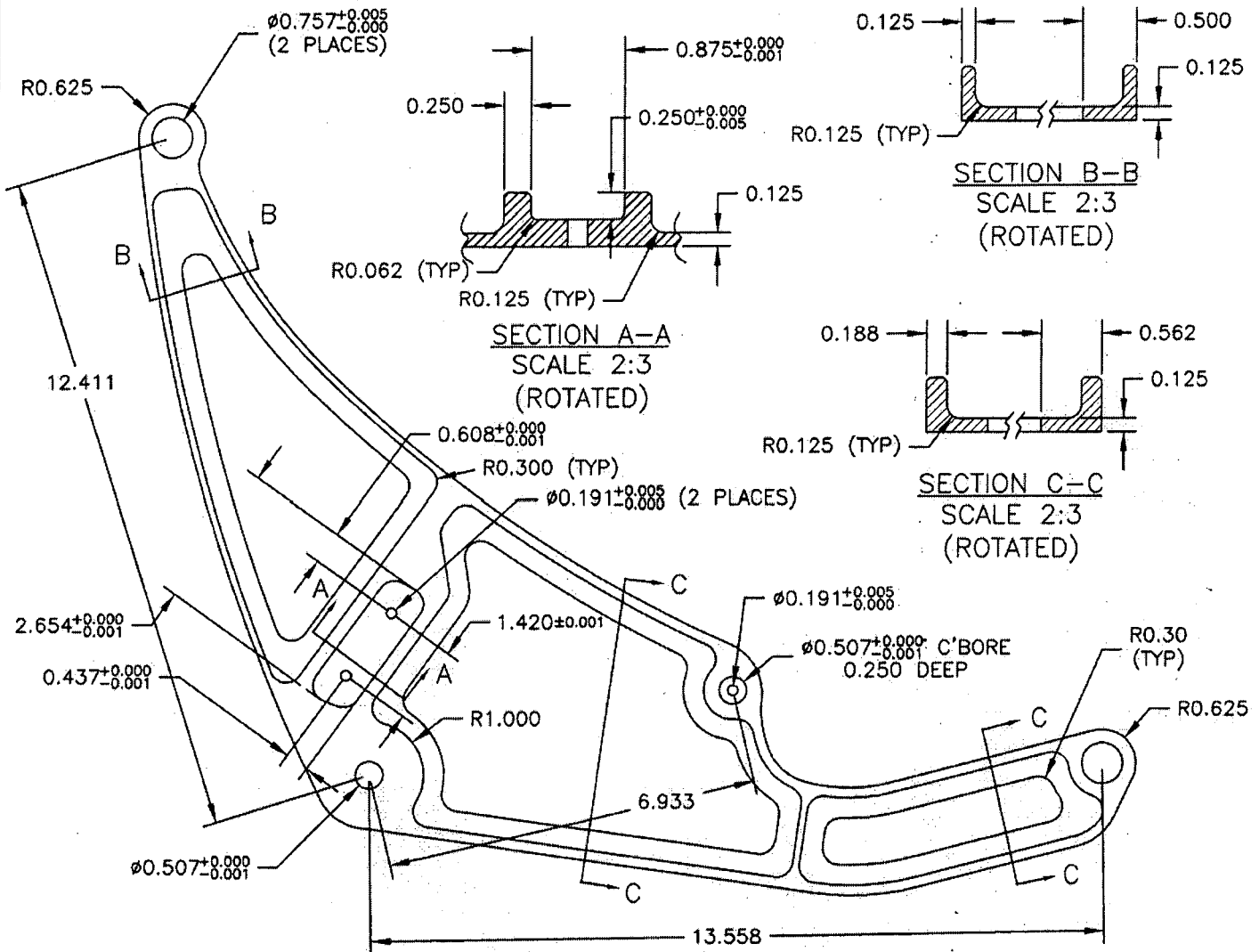
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART

| | | | | | |
|---------|--------------------|-------------------------|--------------------|-----------------------------|--------------|
| DESIGN | CP | DRAWN BY | CP | DART AEROSPACE LTD | REV. B |
| | | | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | DRAWING NO. D2803 | SHEET 1 OF 2 |
| DATE | 04.11.22 | TITLE | STA 84 BRACKET | SCALE | 1:3 |
| A | 00.11.07 | NEW ISSUE | | | |
| B | 04.11.22 | ADD CUTOUTS & -043/-044 | | | |

RELEASED

05.03.11 *[Signature]***D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

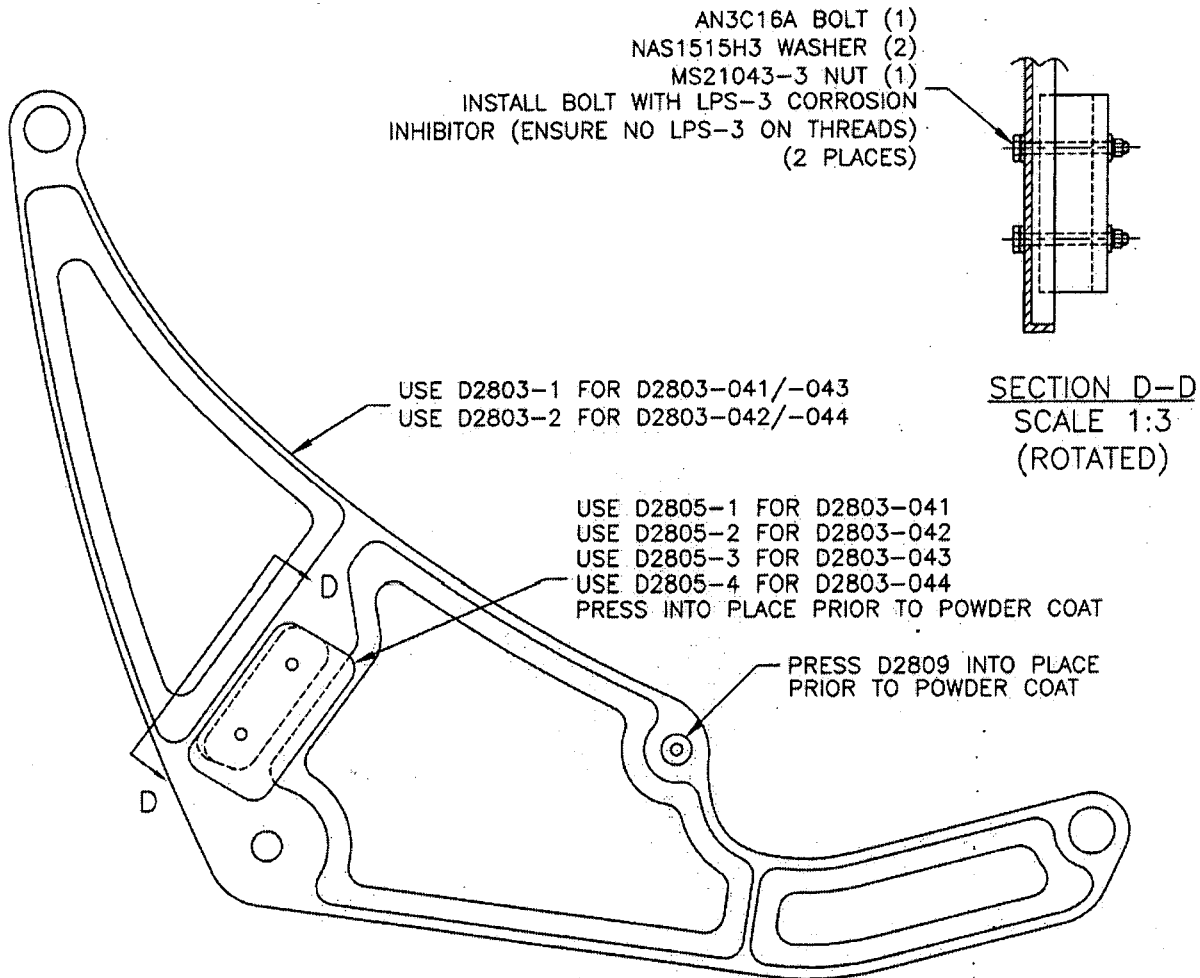
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NO. 26564

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DART

| | | | | | |
|---------|--------------------|----------|--------------------|---|------------------------|
| DESIGN | CP | DRAWN BY | CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | DRAWING NO. D2803 | REV. B SHEET 2 OF 2 |
| DATE | 04.11.22 | | | TITLE STA 84 BRACKET | SCALE 1:3 |



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RELEASED

05-03-11

**D2803-041/-043 BRACKET ASS'Y (SHOWN),
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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